

NCP-19-7638



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D206-667-147TRN
Job Sheet 195415



Part No: D206-667-147TRN

Job Qty: 1 pcs

Part Name: Crosstube Assembly, Mid Fwd



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/22/19

Job Tracking No:

Due Date: 6/14/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D206-667-147 REV.B IPP rev:A 11.01.06 new Issue DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		DAS Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Mori Seiki TL-40 - 1	1 pcs	6/14/19	6/14/19	3.21	1.47	Mori Seiki TL-40 - 1		66 2019-05-23
110	QC 2	1 pcs	6/14/19	6/14/19	0.00	0.00	QC 2 - 1		9-89
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		DAS
							QC 2 - 66		66 2019-05-23
							QC 2 - 64		9-89
							QC 2 - 65		

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P.T.O.

						QC 2 - 5	
						QC 2 - 71	
120	Mori Seiki TL-40 - 1 - B4B	1 pcs	6/14/19	0.00	1.47	QC 2 - 73	DAS
						Mori Seiki TL-40 - 1 - B4B	66 2019-05-24
130	QC 2	1 pcs	6/14/19	0.00	0.00	QC 2 - 1	9-89
						QC 2 - 12	
						QC 2 - 14	
						QC 2 - 17	
						QC 2 - 19	
						QC 2 - 2	
						QC 2 - 20	
						QC 2 - 22	
						QC 2 - 23	
						QC 2 - 25	
						QC 2 - 32	
						QC 2 - 33	
						QC 2 - 35	
						QC 2 - 39	
						QC 2 - 4	
						QC 2 - 40	
						QC 2 - 44	
						QC 2 - 45	
						QC 2 - 48	
						QC 2 - 49	
						QC 2 - 50	
						QC 2 - 51	
						QC 2 - 52	
						QC 2 - 57	
						QC 2 - 62	
						QC 2 - 63	
						QC 2 - 8	DAS
						QC 2 - 66	66 2019-05-24
						QC 2 - 64	9-89
						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 8 - 12	
140	QC 8	1 pcs	6/14/19	0.00	0.00	QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	DAS
						QC 8 - 67	67 19-06-12
						QC 8 - 1 (A)	9-89
						QC 8 - 47	
						QC 8 - 40	

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145	Crosstubes - 2 - B4B	1 pcs	6/14/19	0.00 0.25	QC 8 - 52	
					QC 8 - 23	
					Crosstubes - 1 - B4B	
					Crosstubes - 2 - B4B	GP 19-06-18
150	Crosstubes - 3 - B4B	1 pcs	6/14/19	0.00 0.13	Crosstubes - 3 - B4B	
					Crosstubes - 4 - B4B	
					Crosstubes - 1 - B4B	
					Crosstubes - 2 - B4B	
160	QC 7	1 pcs	6/14/19	0.00 0.00	Crosstubes - 3 - B4B	JUL 09 2019
					Crosstubes - 4 - B4B	
					QC 7 - 10	
					QC 7 - 13	
170	Packaging 3-1 - Stock - B4B	1 pcs	6/14/19	0.00 0.00	QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	JW/BB
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					Packaging 3 - 1 - B4B	BB
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
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					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	

				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	1 pcs	6/14/19	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	70
				QC 21 - SA - 53	

Part Op 100 - Mori Seiki TL-40 (Mori Seiki CNC Lathe Large) 1-Fill tube with sand & install plugs 206-147 on both ends as per Descriptions: Follo FB029 2-Turn first side as per Follo FB029 3-Blend transition lines only with belt sander 60 grit.
 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - Mori Seiki TL-40 (Mori Seiki CNC Lathe Large) 1-Turn second side as per Follo FB029 2-Blend transition lines only with belt sander 60 grit.
 130 - (QC2- Inspect parts off machine FAI/FAIB)
 140 - r)) Production .0000 * Attachments 140 QC QC8 (QC8- Inspect parts - second check)
 145 - (Crosstubes) GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.
 150 - (Crosstubes) 1- handfinish X-TUBE INSIDE AND OUT
 160 - (QC7-Inspect Chemical Conversion Coat)
 170 - (Identify as per dwg & Stock Location: LOCATION : LG014
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6002-115	Crosstube Material	1 pcs (1 ea)	100-Mori Seiki TL-40 - 1	F123961

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Mori Seiki TL-40 - 1	D6002-115	1	71	0

Part Specifications	
Specifications could not be found.	



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 CANADA
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 Email: sales@dartaero.com
 www.dartaerospace.com

Plex 5/22/19 10:45 AM Dart.lajeunesse.marie

Container No: \$183659



Part: D206 - 667 - 147TRN

Job No: 195415

Serial No/Batch: \$183659

Revision: B

Inspector:

Exp Date:

Instructions:

Date: 05/23/19

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DART AEROSPACE LTD	Work Order:	195915
Description: Crosstube Assembly, Mid Fwd	Part Number:	D206-667-147
Inspection Dwg: D206-667-147 Rev: B		Page 1 of 2

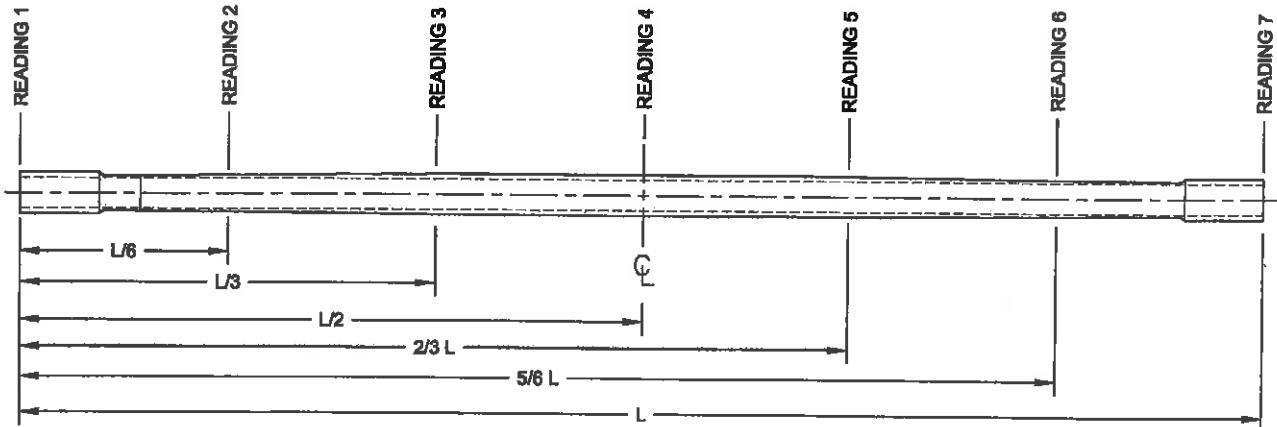
FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.238		✓	CNC-04	0.002" undersize
	1.984	+0.005/-0.000	1.988	✓		CNC-08	
	2.019	+0.005/-0.000	2.023	✓		CNC-04	
	2.058	+0.005/-0.000	2.063	✓			
	2.097	+0.005/-0.000	2.102	✓			
	2.136	+0.005/-0.000	2.141	✓			
	2.176	+0.005/-0.000	2.180	✓			
	0.125	+/-0.010	.124	✓		CNC-08	
	R0.063	+/-0.010	.063	✓		RG	
	R2.00	+/-0.010	2.000	✓			
	R0.063	+/-0.010	.063	✓			
	4.438	+/-0.030	4.440	✓		CNC-08	
SIDE B	2.240	+0.005/-0.000	2.240	✓		CNC-04	
	1.984	+0.005/-0.000	1.989	✓		CNC-08	
	2.019	+0.005/-0.000	2.024	✓		CNC-04	
	2.058	+0.005/-0.000	2.063	✓			
	2.097	+0.005/-0.000	2.102	✓			
	2.136	+0.005/-0.000	2.140	✓			
	2.176	+0.005/-0.000	2.181	✓			
	0.125	+/-0.010	.129	✓		CNC-08	
	R0.063	+/-0.010	.063	✓		RG	
	R2.00	+/-0.010	2.000	✓			
	R0.063	+/-0.010	.063	✓			
	4.438	+/-0.030	4.440	✓		CNC-08	
	99.84	+/-0.020	99.85	✓		Tape	

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DART AEROSPACE LTD	Work Order:	195415
Description: Crosstube Assembly, Mid Fwd	Part Number:	D206-667-147
Inspection Dwg: D206-667-147 Rev: B		Page 2 of 2

WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L=0"	.248	.245	.262	.261	.017	0.035"
READING 2 L=16.64	.168	.165	.178	.179	.014	
READING 3 L=33.28	.249	.247	.260	.260	.013	
READING 4 L=49.92	.252	.249	.262	.264	.015	
READING 5 L=66.56	.247	.244	.261	.262	.018	
READING 6 L=83.20	.165	.163	.179	.181	.018	
READING 7 L=99.84	.245	.240	.260	.264	.024	

Calibration Result

Actual Block Thickness: 100-300

Sitescan 250 Measured Thickness: 100-300

Measured by:	DAS 66 9-89	Audited by:	DAS 67 9-89	Preliminary Approval:	
Date:	2019-05-24	Date:	19-06-12	Date:	

Rev	Date	Change	Revised by	Approved
B	11.06.21	New Issue	KJ	
C	12.06.04	Wall thickness form added	KJ	
D	19.05.01	Drawing Revision Change	MG	M.

Item	Qty -147	Part Number	Description
1	X	D206-667-147	CROSSTUBE ASSEMBLY (206L MID FWD)
2	1	D6002-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
9	A/R	PROSEAL	SEALANT, AMS-S-8802 CLASS B-2
10	2	AN742D36	CLAMP
11	2	MS9185-05	ANGLE BRACKET
12	2	MS21042L3	NUT (OR MS21042-3)
13	2	MS27039-1-08	SCREW
14	4	NAS1149C0332R	WASHER (OR AN960C10L)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 99.84±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-147" AND BATCH NUMBER ON INSIDE OF CUFF PER DART QSI 044 6.4 (VIBRATING STYLUS).
- 7) WEIGHT: 15.0 lbs (-507 = 12.84)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) TO INSTALL D2891-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.
- 16) MASK AREA UNDER CLAMP PRIOR TO PAINTING.
- 17) SEAL EDGES WHERE AN742D36 CLAMP MEETS WITH THE CROSSTUBE USING SIKAFLEX-241/-291 OR MIL-S-8802 CLASS B2 OR PROSEAL 890 SEALANT.
- 18) PERFORM RESISTANCE CHECK TO ENSURE MAX RESISTANCE IS 10 MEGOHMS.

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WORK ORDER

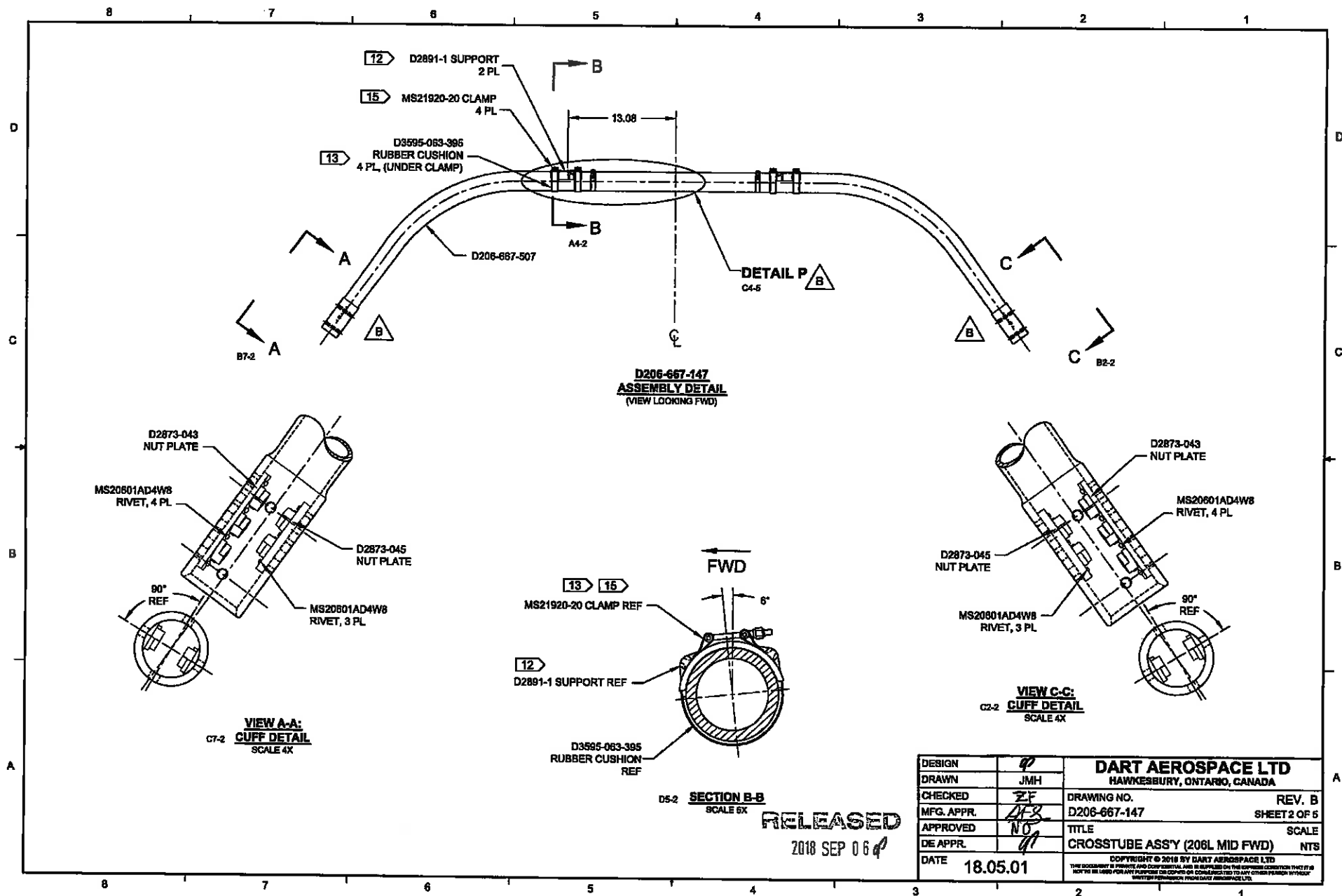
NO. 195915-415
19-05-02

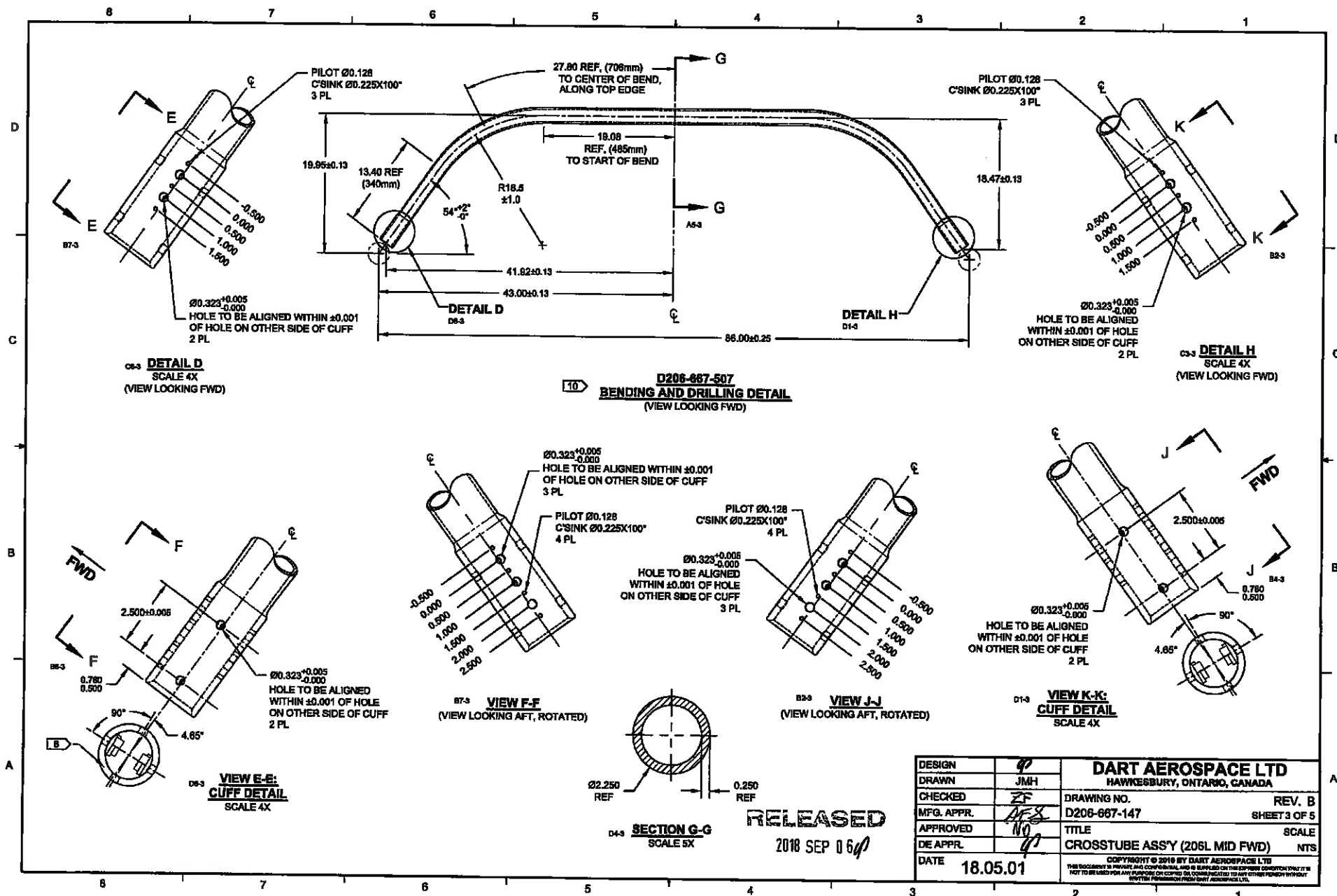
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E.N. 14-717

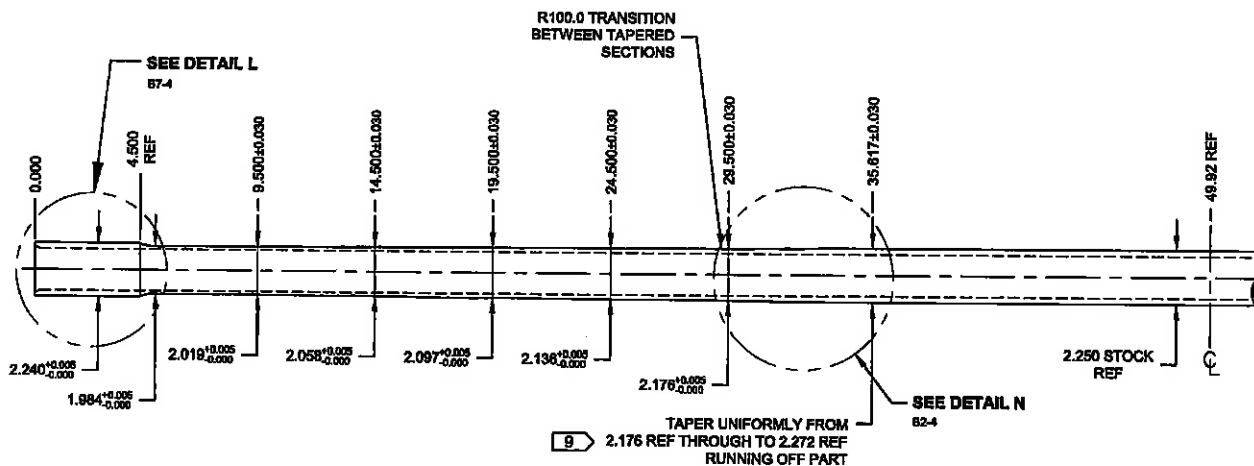
B	REVISE SHEET 2 ASSEMBLY DETAIL HOLE PATTERN PER CAR18-221. UPDATE PARTS LIST AND GENERAL NOTES 12 & 15 TO INCORPORATE DEO A-1. ADD ITEMS 10-14 TO PARTS LIST, ADD GENERAL NOTES 16-18 AND ADD SHEET 5 TO INCORPORATE DEO A-2.	JMH	18.05.01
A	NEW ISSUE	CP	10.11.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	JMH		
CHECKED	ZE		
MFG. APPR.	24-2		
APPROVED	NO		
DE APPR.			
DATE	18.05.01		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D206-667-147	REV. B SHEET 1 OF 5
TITLE CROSSTUBE ASSY (206L MID FWD)	SCALE NTS
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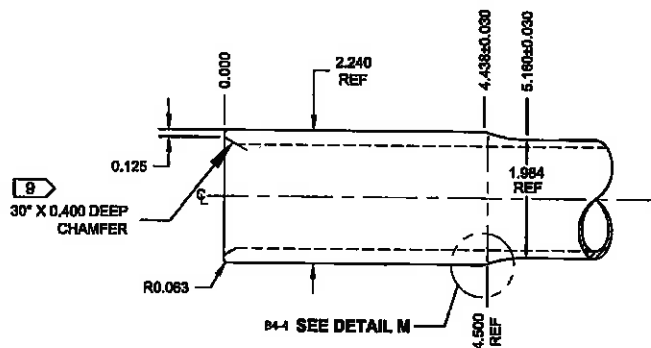




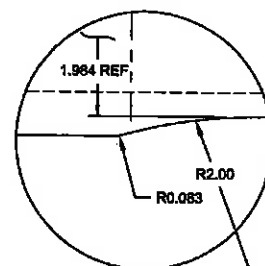
DESIGN	40	DART AEROSPACE LTD	
DRAWN	JMH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	AFS	D206-667-147	SHEET 3 OF 5
APPROVED	10	TITLE	SCALE
DE APPR.	40	CROSSTUBE ASS'Y (206L MID FWD)	NTS
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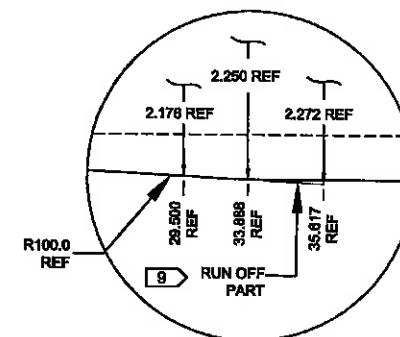
TURNING DETAIL



DETAIL L:
CROSSTUBE CUFF
NOT TO SCALE



DETAIL M:
CUFF TRANSITION
NOT TO SCALE



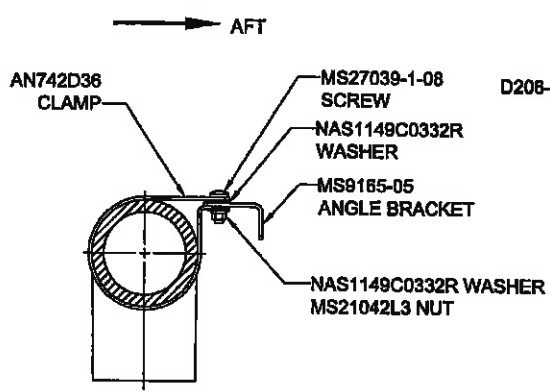
DETAIL N:
TAPER RUN-OFF
NOT TO SCALE

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DRAWN	JMH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	DRAWING NO.	REV.
MFG. APPR.	ZF	D206-667-147	SHEET 4 OF
APPROVED	NO	TITLE	SCALE
DE APPR.	9	CROSSTUBE ASS'Y (206L MID FWD)	NT
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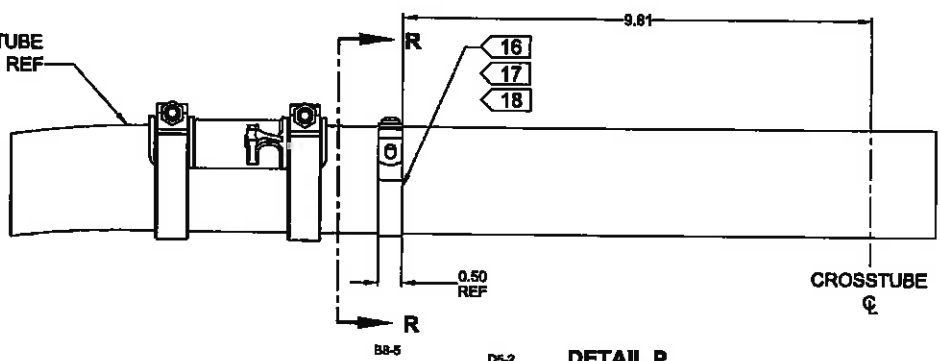
8 7 6 5 4 3 2 1

D
C
B
A



C4-5 **SECTION R-R**
B

D208-667-507 CROSSTUBE REF



D5-2 **DETAIL P**
BONDING STRAP INSTALLATION 2 PL

RELEASED
2018 SEP 06

DESIGN	JP	DART AEROSPACE LTD	
DRAWN	JMH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	DES	D208-667-147	SHEET 5 OF 5
APPROVED	NO	TITLE	SCALE
DE APPR.	JP	CROSSTUBE ASS'Y (208L MID FWD)	NTS
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8 7 6 5 4 3 2 1

Entered:

Date:

JR Oct 28/19



NCR No.

19-7638

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>195415</u> Part No. <u>D206-667-142 TRN</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☒ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐																															
Date: <u>11/6/4</u>		Sequence #: <u>100</u>		QTY Affected: <u>1</u>		MRB (QSI042) <u>11/12/4</u>																													
Description Work Order Deviation				Disposition																															
One cuff is O.D. is undersized by 0.003"				Acceptable. Cuff is not under high stress.																															
				Completed By <u>11/12/4</u> Lead hand / Supervisor <u>19-08-26</u> QC / QA Coordinator <u>68</u> 9-89 JUL 25 2019																															
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☒ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>						☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☒ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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